

Reg. mail P 51X605 185

PUGET SOUND AIR POLLUTION CONTROL AGENCY

110 Union Street, Suite 500, Seattle, Washington, 98101-2038
Fax 206-343-7522

Registration No. 11339

Case No. _____

COMPLIANCE STATUS REPORT

Date of Report Jan 10, 1997 at _____m.

Source Name <u>Ash Grove Cement Co.</u>	Responsible Person, Title <u>Henrick Voldbaek Manager</u>
Location <u>3801 E. Marginal Way So. Seattle, 98134</u>	

☐ No violations of PSAPCA's regulations were observed at the time of my inspection, with respect to the areas of the facility I inspected.

☒ During my inspection I noted the following deficiencies:

During our review of your October
CEM report we noted that on 10/13
and 10/14 less than 90% valid hours
were reported for each day.

Reg. I section 12.03(4)(4)

Please submit a written report within ten (10) working days describing the necessary corrective action you have taken or propose to take, including a schedule, to address the above deficiencies.

Issued by

Elizabeth Giff

Received by

Signing this is not an admission of guilt

ASH GROVE CEMENT COMPANY



"WESTERN REGION"

January 27, 1997

Ms. Elizabeth Gilpin
Puget Sound Air Pollution Control Agency
110 Union Street, Suite 500
Seattle, WA. 98101-2038

Re: Compliance Status Report January 13, 1997

Dear Ms. Gilpin:

You requested additional information in regards to the above CSR's.

CEM report for October 1996:

The CEM reported data for October 13 and 14 did not contain less than 90% valid hours. The October report submitted reflects the following:

For October 13, 1996, the report shows that the emission monitors operated at 100% or 23 of the 23 hours of kiln operation.

For October 14, 1996, the report shows that the emission monitors operated at 96% or 23 of the 24 hours of kiln operation. The October 1996 addendum to CEM explains that the monitors were down from 11:30 a.m. to 12:15 p.m. for calibration and general maintenance.

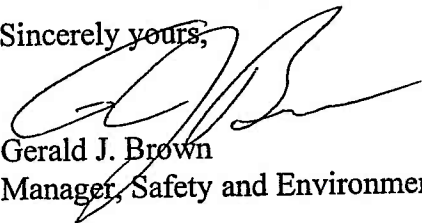
CEM report for November 1996:

The November 1996 CEM report does show on November 18, 1996 emission monitors operated at 80% or 19 of the 24 hours of kiln operation. The November 1996 addendum to CEM explains that the monitors were down from 08:45 a.m. to 2:00 p.m. for maintenance on the SO2 analyzer. This action was necessary in order to correct a drift fault experienced by the analyzer. Please note that up to this time only a basic level maintenance was necessary to keep the SO2 analyzer operational but on November 18, a specialist level maintenance was required to remedy the problem.

This incident did not violate any PSAPCA rule. Regulation I section 12.03(h) specifies how much monitor down time invalidates the data, but Regulation I does not currently impose any minimum data recovery requirement for CEM operators. The draft article 12 amendments currently under development by PSAPCA would impose such a requirement. Even under the draft rule, down time due to CEM maintenance would not be a violation.

I hope this response provides the information you require.

Sincerely yours,

A handwritten signature in black ink, appearing to be 'GJ Brown', written over the printed name and title.

Gerald J. Brown
Manager, Safety and Environment

cc: Henrik Voldbaek
Nate Fernow

Ext Mail 371603785

PUGET SOUND AIR POLLUTION CONTROL AGENCY

110 Union Street, Suite 500, Seattle, Washington, 98101-2038
Fax 206-343-7522

Registration No. 1139

Case No. _____

COMPLIANCE STATUS REPORT

Date of Report Jan 10, 19 97 at _____ .m.

Source Name <u>Ash Grove Cement Co.</u>	Responsible Person, Title <u>Henrick Voldback Manager</u>
Location <u>3801 E. Marginal Way So. Seattle, WA</u> <u>98134</u>	

☐ No violations of PSAPCA's regulations were observed at the time of my inspection, with respect to the areas of the facility I inspected.

☒ During my inspection I noted the following deficiencies:

Reg. I 12.04 (H)
November 18th CEM data contained
less than 90% Valid hours when the kiln
was operating.

Please submit a written report within ten (10) working days describing the necessary corrective action you have taken or propose to take, including a schedule, to address the above deficiencies.

Issued by *Elizabeth Gilpin*

Received by _____
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PUGET SOUND AIR POLLUTION CONTROL AGENCY

110 Union Street, Suite 500, Seattle, Washington, 98101-2038
Fax 206-343-7522

JUL 9 1996

Registration No. 11339

Case No. AGCW-SEATTLE

COMPLIANCE STATUS REPORT

Date of Report 7-8, 19 96 at _____ .m.

Source Name <u>Ash Grove Cement Co.</u>	Responsible Person, Title <u>Henrik Voldbaek, Plant Mgr</u>
Location <u>3801 E. Marginal Wy S</u> <u>Seattle, WA 98134</u>	

☐ No violations of PSAPCA's regulations were observed at the time of my inspection, with respect to the areas of the facility I inspected.

☒ During my inspection ^{of May 1996 CEM report} I noted the following deficiencies:

- ① Need to define periods of startup and shutdown of the kiln so Agency can determine whether N/C 5730 Condition 6 or Condition 7 applies
- ② Need to include time periods during which emission standards are violated (Reg I Section 12.04(f)(1))

Please submit a written report within ten (10) working days describing the necessary corrective action you have taken or propose to take, including a schedule, to address the above deficiencies.

Issued by

M. M. Gue

Received by

Signing this is not an admission of guilt

ASH GROVE CEMENT COMPANY

WESTERN R

Post-it™ Fax Note 7671		Date 3/21/96	# of pages 1
To Elizabeth Gilpin	From G J Brown		
Co./Dept. PSAPCA	Co. AGC		
Phone #	Phone #		
Fax #	Fax #		

Sent 4:15

March 21, 1996

Ms. Elizabeth Gilpin
Puget Sound Air Pollution Control Agency
110 Union Street, Suite 500 Seattle, WA. 98101-2038

Re: Compliance Status Report - March 20, 1996

Dear Ms. Gilpin:

The operation of PF Bin dust collector #463.110 was inspected on this date and determined to be operating normally. The air pressure for the pulse cleaning cycle, however, was found to be higher than necessary and this caused an over cleaning of the bags in the dust collector. This air pressure has been adjusted and I could not detect any visible emissions.

Sincerely,



Gerald J. Brown
Manager, Safety and Environment

cc: HV
NF
BM

PUGET SOUND AIR POLLUTION CONTROL AGENCY

110 Union Street, Suite 500, Seattle, Washington, 98101-2038
Fax 206-343-7522

Registration No. 11339

Case No. _____

COMPLIANCE STATUS REPORT

Date of Report March 20th, 19 96 at 5:00 pm.

Source Name <u>Ash Grove Cement Co.</u>	Responsible Person, Title <u>Gerry Brown</u>
Location <u>3801 E. Marginal Way So. Seattle 98134</u>	

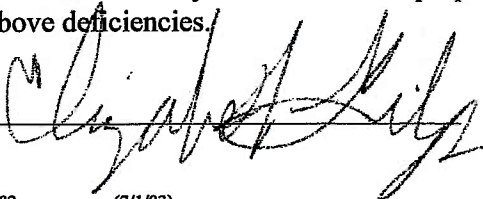
☐ No violations of PSAPCA's regulations were observed at the time of my inspection, with respect to the areas of the facility I inspected.

☒ During my inspection I noted the following deficiencies:


Reg. I sec 9.20 Maintenance of equipment
Baghouse equipment (# 463 110)
Visible emissions detected from the
pulverized coal silo baghouse during the
pulse cycle.
Determine cause of VE from Baghouse
and correct situation

Please submit a written report within ten (10) working days describing the necessary corrective action you have taken or propose to take, including a schedule, to address the above deficiencies.

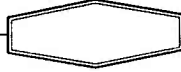
Issued by



Received by


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ASH GROVE CEMENT COMPANY



"WESTERN REGION"

July 16, 1996

Mr. Fred Austin,
Puget Sound Air Pollution Control Agency
110 Union Street, Suite 500 Seattle, WA. 98101-2038

Re: Compliance Status Report July 8, 1996

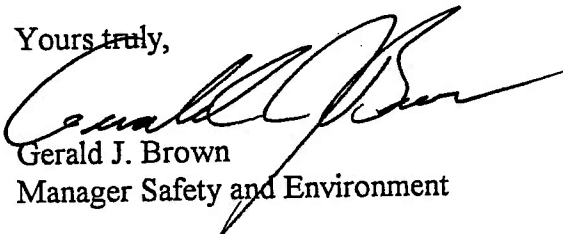
Dear Mr. Austin:

In the above CSR, PSAPCA requested 1) additional information defining periods of start up and shutdown of the kiln and 2) time periods during which emission standards are exceeded for the May 1996 CEM report.

- 1) With the exception of the May 26, 1996 opacity event which resulted from a broken bag in the main baghouse, all other exceedances reported occurred during kiln start up.
- 2) The time periods during which emission standards are exceeded have been identified in the addendum to the May 1996 CEM report.

I hope that this response provides you with the information you require.

Yours truly,



Gerald J. Brown
Manager Safety and Environment

Copy: Henrik Voldbaek
Nate Fernow
Doug Hale

ASH GROVE CEMENT COMPANY



"WESTERN REGION"

FACSIMILE COVER SHEET

DATE: 4/30/97

TO: Elizabeth Gilpin
CC: Fred Austin
COMPANY: Puget Sound Air Pollution Control Agency
FAX: (206) 343-7522

FROM: Trygve Grey
PHONE: (206) 623-5596 x202
FAX: (206) 623-5355

TOTAL NUMBER OF PAGES: Two (2)

SUBJECT: 4/25/97 Site visit

In response to the deficiencies noted on your visit of 4/25/97, the following is a printout from our work order system showing the bag house for cement bulk loading out of our Group II silos was rebagged Sunday, 4/27/97. No dusting has been noticed since.

Trygve Grey
Process Engineer

AGCS2M000682

Ash Grove Cement - Seattle
Prepared: 4/30/97 12:22

W O R K O R D E R S C O M P L E T E D
All Crafts
4/27/97 To 4/27/97

Page 1 WOPWOACT

WO #	Description	Type	Pri	St	Equipment	Submitted By	Date	Date Completed	Est Hours	Act Hours
Craft: PM DUST CONTROL SP										
705054	CHANGE OUT D/C BAGS	RE	3	C	910300 D/C GP2,RAIL\TRUCK SIDE,L JLANGL		4/28/97	4/27/97	8.00	16.00
Total PM DUST CONTROL SP		Completed:		1				Total Hours:	8.00	16.00
Final Totals		Completed:		1				Total Hours:	8.00	16.00

PUGET SOUND AIR POLLUTION CONTROL AGENCY

110 Union Street, Suite 500, Seattle, Washington, 98101-2038
Fax 206-343-7522

Registration No. 11339

Case No. _____

COMPLIANCE STATUS REPORT

Date of Report April 25, 19 97 at 8:30 A.m.

Source Name <u>Ash Grove Cement Co.</u>	Responsible Person, Title <u>Trygve Grey</u>
Location <u>3801 E Marginal Way So. Seattle, WA.</u>	

☐ No violations of PSAPCA's regulations were observed at the time of my inspection, with respect to the areas of the facility I inspected.

☒ During my inspection I noted the following deficiencies:

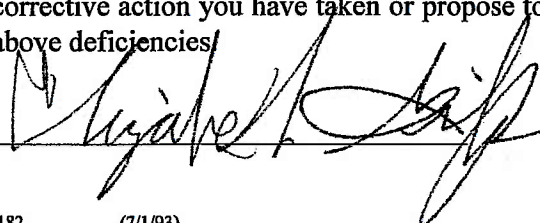
Reg I 9.20 Equipment and
components shall be maintained in good
working order

We observed significant dust coming
from the 910.200 BagHouse Cement bulk
loading

Please repair and submit corrective
Action to the Agency.

Please submit a written report within ten (10) working days describing the necessary corrective action you have taken or propose to take, including a schedule, to address the above deficiencies

Issued by



Received by

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PUGET SOUND AIR POLLUTION CONTROL AGENCY

110 Union Street, Suite 500, Seattle, Washington, 98101-2038
Fax 206-343-7522

Registration No. 11339

Case No. _____

COMPLIANCE STATUS REPORT

Date of Report 2-12

Source Name <u>Ash Grove Cement Co</u>	Responsible Person, Title <u>Gerald Brown, Env. Mgr.</u>
Location <u>3801 E. Marginal Wys</u> <u>Seattle, WA 98134</u>	

☐ No violations of PSAPCA's regulations were observed at the time of my inspection, with respect to the areas of the facility I inspected.

☒ During my inspection I noted the following deficiencies:

① Particulate emissions at base of kiln
near cooler end while standing just
north of clay pile

Please submit a written report within ten (10) working days describing the necessary corrective action you have taken or propose to take, including a schedule, to address the above deficiencies.

Issued by M. M. Gye

Received by [Signature]
Signing this is not an admission

ASH GROVE CEMENT COMPANY



"WESTERN REGION"

February 21, 1997

Ms. Melissa McAfee
Puget Sound Air Pollution Control Agency
110 Union Street, Suite 500 Seattle, WA. 98101-2038


Re: Compliance Status Report - February 12, 1997

Dear Ms. McAfee:

In response to the above, the area has been under observation to determine the source of particulate noted on February 12, 1997. We cannot definitively locate the source since no signs of emissions are visible. It is belief that material on the roof of the pan conveyer enclosure may have been caught by the swirling wind and this is what you felt. This area is in the process of being cleaned.

Should the problem reoccur, we will continue our efforts to determine a source.

Sincerely,



Gerald J. Brown
Manager, Safety and Environment

cc: HV
NF

AGCS2M000686

PUGET SOUND AIR POLLUTION CONTROL AGENCY

110 Union Street, Suite 500, Seattle, Washington 98101-2038

Fax: 206-343-7522

Registration No. 11339

Elizabeth Gilpin

Case No. _____]

COMPLIANCE STATUS REPORT

Date of Report 7-30, 19 97 at 1045a m.

Source Name <u>Ash Grove</u>	Responsible Person, Title <u>Gerald Brown, Env. Mgr.</u>
Location <u>3801 E. Marginal Wy S.</u> <u>Seattle, WA 98134</u> <u>623-5596</u>	

☐ No violations of PSAPCA's regulations were observed at the time of my inspection, with respect to the areas of the facility I inspected.

☒ During my inspection I noted the following deficiencies:

- ① Need to record daily average weights of all fuels consumed by kiln (tire fuel not recorded) to comply with N/C 5755 Conditions 6 and Fuel Monitoring Plan method of compliance A(c).
- ② Clean up dust accumulations at base of main kiln baghouse (Reg I Section 9.15 (a) + (c))
- ③ Update written QC program for CEMS to ensure compliance with Reg I Article 12.03 (e) + (f) and 40 CFR Part 60 Appendix F
- ④ Submit calibration records for measuring devices for continuous determination of weight of all fuels entering kiln per N/C 5755 Cond 6 + 5 and Fuel Monitoring Plan method of compliance 6(A)(b)

Please submit a written report within ten (10) working days describing the necessary corrective action you have taken or propose to take, including a schedule, to address the above deficiencies.

Issued by: M Mc

Received by: [Signature]

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ASH GROVE CEMENT COMPANY



"WESTERN REGION"

September 17, 1997

Ms. Melissa McAfee
Puget Sound Air Pollution Control Agency
110 Union Street, Suite 500 Seattle, WA. 98101-2038

Re: Q/C program written revision

Dear Ms. McAfee:

In August, it was anticipated that the process to update the written Q/C program would be complete on September 12., Unfortunately, we have been unable to accomplish this task by this date and now expect the process will finished on or about October 17, 1997.

Very truly yours,

Gerald J. Brown
Manager, Safety and Environment

cc: HV
CA

ASH GROVE CEMENT COMPANY



"WESTERN REGION"

August 11, 1997

Ms. Melissa McAfee
Puget Sound Air Pollution Control Agency
110 Union Street, Suite 500 Seattle, WA. 98101-2038

Re: Compliance Status Report - July 30, 1997

Dear Ms. McAfee:

Item #1

In regards to N/C 5755 condition 5 and 6, the daily average weight of tire fuel is recorded by the SDR system. Data on gas, coal and tire fuel usage is generated daily. Although this data is available and can be obtained, we are modifying records to reflect this in a simpler format. Attached is an example of the revised format

Item #2 Accumulation of feed material at base of main baghouse has been removed.

Item #3 The written Q/C program is currently being revised. We anticipate this process will require until September 12 to complete.

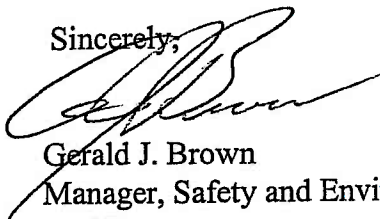
Item #4 Calibration records for measuring devices for weight determination of kiln fuels.

Coal : On June 10, 1997 Each Pfister feeder was emptied and inspected. A zero curve correction was performed followed by a function test weight in accordance with Pfister technical instructions. Both units were within 1% on the zero. During the function test with the test weight the kiln pfister was approximately 2.5% light and was adjusted. The calciner Pfister was approximately 2% light and was adjusted.

Tires: Weightech Corp. has been contracted to verify weigh belt calibration. This service is provided approximately every 3 months. Attached are calibration records for April and July .

Natural Gas: Invoice records provided by the gas supplier are used to verify the plant's system for measuring fuel usage.

Sincerely,



Gerald J. Brown
Manager, Safety and Environment
cc: HV

AGCS2M000689

WEIGH SCALE... TIRE SCALE PULSE 1 = 10LB
 KILN CLINKER BELT SCALE... NATURAL GAS TON/HR
 FLOW RATE KILN PF. FEED... TOTAL FUEL IN TPH
 FLOW RATE CALC. PF. FEED... PERCENT OF FUEL AS GAS
 WEIGHFEEDER... TIRES
 WEIGHFEEDER...

461010.FIL 463210.FIL 471190.FIL 455075.FIL TIREBURNPULS TOTFUEL-TPH
 461120.FIL 463140.FIL TIRECOUNTER 455.075 GAS-TPH TIRE-WT90T

H:M	t/h	t/h	t/h	t/h	t/h	Hour	t/h	t/h	%
7:00	4.7	4.5	1.52	7.7	96.7	3084 2904.7	--	34.59	0.1 10.61 12.45
8:00	4.9	4.5	1.52	7.4	89.2	155 3018.7	--	1.49	0.1 10.50 14.18
9:00	5.0	4.5	1.52	7.4	80.5	284 2871.7	--	2.99	0.1 10.57 14.58
10:00	5.5	4.9	3.40	5.9	80.5	422 2985.7	--	4.57	0.1 10.62 11.12
11:00	5.5	4.9	3.39	5.0	90.1	570 3112.8	--	5.78	0.1 10.71 11.67
12:00	5.5	4.9	1.52	7.5	82.1	719 3116.8	--	7.25	0.1 10.55 15.75
13:00	5.5	4.9	1.52	7.4	74.8	852 2911.7	--	8.61	0.1 10.38 12.77
14:00	5.5	4.9	1.53	7.5	103.5	1010 3276.7	--	10.10	0.1 10.55 15.35
15:00	5.5	4.9	1.53	7.1	68.6	1165 2915.7	--	11.60	0.1 10.34 15.67
16:00	5.5	4.9	1.53	7.1	87.1	1315 2769.7	--	13.10	0.1 9.95 12.84
17:00	5.5	4.9	1.53	7.1	76.4	1462 2592.6	--	14.59	0.1 9.95 12.70
18:00	5.5	4.9	1.53	7.1	57.7	1612 0.0	--	15.86	0.1 8.69 0.00
19:00	5.3	4.8	1.61	7.1	95.7	1771 3007.7	--	17.34	0.1 10.26 14.59
20:00	5.0	4.8	1.49	7.1	76.0	1928 3276.7	--	18.84	0.1 10.42 16.66
21:00	5.1	4.7	1.61	7.2	77.6	2077 3267.3	--	20.34	0.1 10.62 16.52
22:00	5.0	4.6	1.61	7.2	151.0	2235 2369.6	--	21.85	0.1 10.29 13.45
23:00	5.0	4.6	1.73	6.5	78.1	2396 2662.7	--	23.32	0.1 9.87 15.57
0:00	5.0	4.5	1.73	7.0	74.2	2548 2976.7	--	24.82	0.1 10.15 12.96
1:00	5.2	4.5	1.73	7.0	96.4	2708 3276.7	--	26.25	0.1 10.58 16.68
2:00	5.2	4.6	1.73	7.1	78.7	2870 3201.8	--	27.71	0.1 10.56 15.92
3:00	6.2	0.0	1.73	7.6	97.6	3008 3276.7	--	29.02	0.1 11.52 18.53
4:00	6.2	0.0	1.73	7.2	82.2	3156 2758.7	--	30.52	0.1 10.46 13.17
5:00	5.5	5.2	1.73	7.4	105.3	3314 3153.8	--	31.99	0.1 10.90 15.58
6:00	5.5	5.2	1.73	7.3	159.6	3468 2728.7	--	33.33	0.1 10.57 13.86
7:00	5.4	5.0	1.73	7.1	66.8	3646 2978.7	--	34.74	0.1 10.12 12.24

11 Aug 97 7.00 - 11 Aug 97 7.01

Max	5.4	5.0	1.73	7.1	70.7	3650 3501.9	34.74	0.1	10.33	16.47	
Min	5.4	5.0	1.73	7.1	53.4	3647 2231.6	0.01	0.1	10.02	11.39	
Mean	5.4	5.0	1.73	7.1	63.1	3645 2823.4	0.02	4.36	0.1	10.27	13.71
Accm	0.1	0.1	0.04	0.2	1.4	61 63.5	5756.	0.10	0.0	0.23	

10 Aug 97 7.00 - 11 Aug 97 7.00

Max	6.3	6.1	3.41	7.7	150.7	3646 7014.7	34.74	0.1	12.56	27.11	
Min	4.7	0.0	1.44	5.6	0.6	1 0.0	0.01	0.1	8.20	0.00	
Mean	5.3	4.4	1.81	7.1	82.8	1798 2890.3	24.00	17.44	0.1	10.42	13.77 % Tires
Accm	128.2	105.7	43.41	169.7	1987.6	43149 69362.	5756.	418.41	2.3	250.10	
						16/Tires			Tons Gas		
						213.11					

WEIGHTECH CORP.

25837 Dockton Road S.W.
Vashon, WA. 98070
Phone: (206) 463-9535
Fax: (206) 463-5873

GENERAL REPORT

Customer Address: Ashgrove Cement Co.

Seattle, Wa.

Phone # 206 623-5596 X214

Contact: Mr. Bob Minister

Purchase Order 79601457

Plant Site: Same

Date: July 2, 1997


Distribution Same

Note condition of conveyor belt, material adhering to belt or pulleys, water or foreign substance any features of conveyor design, drive, take-up, structure, uniformity of weight or general conditions around conveyor, loading, weighing or feed location or others unmentioned that will be detrimental to accurate weighing.

MILLTRONICS MMI-100-COMP III-118HF

The unit was visually inspected. The Compu III integrator, speed sensor, load cells, suspension, idler alignment, and tail pulley assembly appeared to be good order.

The Compu III integrator parameters were verified. The conveyor belt was started and limbered. The actual belt length and speed was determined. The tare test were conducted. The span test were conducted using the test weights. The analog output was not calibrated. The calibration results are attached.

Reported By 

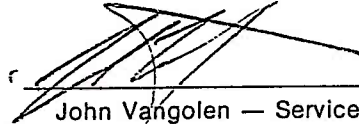
WEIGHTECH

SERVICE CERTIFICATE

This is to certify that on the 2ND day of July, 1997,
(day of month) (month of year) (year)

MILLITRONICS machine(s) COMPTON 118H were calibrated using TEST WT'S
(equipment manufacturer) (machine serial numbers) (method of calibration)

and did meet and/or exceed the accuracy specification.
Weightech further certifies that the above mentioned units
were found to be in good operating condition
and are being satisfactorily maintained.


John Vangolen — Service Mgr.

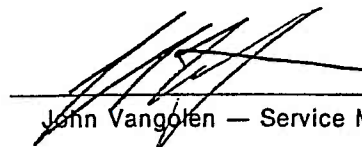
WEIGHTECH

SERVICE CERTIFICATE

This is to certify that on the 18TH day of March, 1997,
(day of month) (month of year) (year)

MILLITRONICS machine(s) AME-118H were calibrated using TEST WEIGHTS
(equipment manufacturer) (machine serial numbers) (method of calibration)

and did meet and/or exceed the accuracy specification.
Weightech further certifies that the above mentioned units
were found to be in good operating condition
and are being satisfactorily maintained.


John Vangolen — Service Mgr.

AGCS2M000692

PFISTER FEEDER CALIBRATION

On 10 June 1997 each Pfister feeder was emptied and inspected.

A zero curve correction was performed followed by a function test with a test weight in accordance with Pfister technical instructions.

Both units were within 1% on the zero.

During the function test with the test weight the Kiln Pfister was approximately 2.5% light and was adjusted.

The Calciner Pfister was approximately 2% light and was adjusted.

ASH GROVE CEMENT - WESTERN REGION SEATTLE PLANT

7/31/97

RAW MATERIALS	RECEIVED / PRODUCED				USED / SHIPPED			INVENTORY
	DAY	MONTH	YEAR		DAY	MONTH	YEAR	
LIMESTONE		83,240	496,916			75,677	485,688	34,526
PACIFIC COAST CLAY		4,503	38,190			5,297	37,949	464
CASTLE ROCK CLAY		4,382	26,688			4,029	26,158	751
SUPERIOR SILICA		7,510	42,912			7,505	42,999	319
IRON ORE		1,727	14,734			2,032	14,298	756
SILICA SALES						5,072	9,522	
KILN FEED								
TYPE I		91,231	588,047			90,011	582,627	
TYPE II								9,741
TOTAL								
FUELS (NET)				MTD				YTD
GAS (mmBTU)				3%		3,968	65,592	6%
COAL (mmBTU)				84%		129,835	890,199	82%
TDF (mmBTU)				13%		19,898	130,026	12%
TOTAL (mmBTU)						153,702	1,085,817	
mmBTU/Ton						2.60	2.83	
CLINKER PRODUCTION		59,218	384,101			59,453	381,795	27,305
SHIPMENTS							19,067	
ADDITIVES								
GYPSUM		77	18,383			2,488	20,014	3,867
GRINDING AID (Lbs)		43,120	222,920			37,774	216,360	29,700
FLY ASH		216	1,846			203	1767	150
HYDRATED LIME		364	2,080			409	2,102	38
CEMENT								
BULK								
TYPE I-S		59,862	377,008			54,218	304,565	21,712
TYPE II-S		0	0			16,057	85,801	0
TYPE III		2,079	24,801			2,983	25,874	10,692
MASONRY - S								0
OIL WELL-S								0
TYPE III-INK								0
MASONRY-INK								0
OIL WELL-MT								0
TOTAL PRODUCED		61,941	401,809			73,258	416,240	
TOTAL RECEIVED								
GRAND TOTAL		61,941	401,809			73,258	416,240	32,403
SACKS								
TYPE II								
TYPE III								
MASONRY								
TOTAL								
EQUIPMENT DATA	RUN TIME				PRODUCTION RATE			REASON FOR DOWNTIME
	DAY	MONTH	YEAR		DAY	MONTH	YEAR	
RAW MILL		486.8	3256.8			187.4	180.6	
KILN		631.7	4060.9			93.7	94.6	
#1 FINISH MILL		503.7	3789.7			50.6	51.2	
#2 FINISH MILL		699.4	4124.5			52.1	50.4	

CHEMICAL ANALYSIS

	Raw Mix	Clinker
TYPE		
SiO2		
Al2O3		
Fe2O3		
CaO		
MgO		
SO3		
LOI		
Na2O		
K2O		
TOTAL		
FREE CaO		
TOTAL ALK.		
C3S		
C2S		
C3A		
C4AF		

CEMENT	Mill #1	Mill #2
7/31/97		
TYPE:		
SiO2		
Al2O3		
Fe2O3		
CaO		
MgO		
SO3		
LOI		
Na2O		
K2O		
TOTAL		
INSOL		
FREE CaO		
TOTAL ALK.		
C3S		
C2S		
C3A		
C4AF		
NC		
VICAT - I		
VICAT - F		
BLAINE		
45 uM		
30 uM		
FALSE SET		
PACK SET		
REFLECT.		

DAYS SINCE L .L.T. I.

0

Plant Report 16

COAL USAGE

CARMEN

5 Aug 97 - 6 Aug 97

TIRE WEIGH SCALE.....TIRE SCALE PULSE 1 = 10LB
 TIRE WEIGH SCALE LB/HR.....
 NUMBER TIRES BEING BURNED.....
 KILN CLINKER BELT SCALE.....
 FLOW RATE KILN PF. FEED.....
 FLOW RATE CALC. PF. FEED.....
 WEIGHFEEDER.....
 WEIGHFEEDER.....

461020.FI1 463210.FI1 471.150.FI1 465075.FI1 TIREBURNPULS
 461120.FI1 463140.FI1 TIRECOUNTER 465.075

TIRES (LBS/HR)
 ✓

H:M	t/h	t/h	t/h	t/h	t/h	Hour
7:00	6.2	6.9	3.45	9.7	87.6	738 0.0 -- 7.34
8:00	6.0	6.5	3.45	9.8	71.7	0 0.0 -- 0.00
9:00	6.0	6.5	3.45	9.4	60.1	0 0.0 -- 0.00
10:00	5.9	6.5	2.04	9.5	55.4	79 2904.7 -- 0.79
11:00	6.0	6.3	3.55	9.4	93.0	202 0.0 -- 1.99
12:00	5.9	6.3	2.07	9.3	28.0	349 2831.7 -- 3.21
13:00	5.9	6.3	1.97	9.2	85.1	490 2889.7 -- 4.71
14:00	5.7	6.1	1.98	9.2	67.9	594 2922.7 -- 6.21
15:00	5.5	5.6	2.02	9.0	53.7	690 2999.7 -- 7.08
16:00	5.5	5.5	2.02	9.1	123.5	842 2988.7 -- 8.37
17:00	5.5	5.5	1.80	9.2	88.2	1003 3276.7 -- 9.87
18:00	5.3	5.3	1.84	9.3	72.4	1161 3230.8 -- 11.37
19:00	5.5	5.3	1.75	9.1	85.0	1305 2721.7 -- 12.87
20:00	4.7	4.8	1.75	9.2	79.0	1453 3276.7 -- 14.32
21:00	4.7	4.8	1.75	9.0	111.4	1593 2476.6 -- 15.83
22:00	4.7	4.8	1.78	8.6	74.9	1749 2227.5 -- 17.32
23:00	4.7	4.8	1.78	8.4	69.4	1918 3270.8 -- 18.61
0:00	4.7	4.8	1.78	8.5	55.5	2083 2831.7 -- 20.31
1:00	4.8	4.8	1.64	8.5	84.5	2250 3276.7 -- 21.81
2:00	4.7	4.8	1.64	8.8	66.7	2406 3131.8 -- 23.31
3:00	4.7	4.8	1.55	8.7	134.3	2569 2032.5 -- 24.80
4:00	0.0	6.2	1.58	8.8	71.3	2703 3276.7 -- 26.09
5:00	0.0	6.3	1.58	8.8	27.1	2864 2966.7 -- 27.59
6:00	5.1	6.1	1.66	8.9	80.9	3032 3157.8 -- 29.09
7:00	6.0	6.1	1.71	9.0	79.5	3184 2659.6 -- 30.53

6 Aug 97 7.00 - 6 Aug 97 7.01

Max	6.0	6.1	1.71	9.0	89.2	3188 3073.8	30.53
Min	6.0	6.1	1.71	9.0	58.3	3185 2375.6	0.01
Mean	6.0	6.1	1.71	9.0	76.2	3186 2805.0 0.02	4.37
Accm	0.1	0.1	0.03	0.2	1.5	62 54.6 5647.	0.09

5 Aug 97 7.00 - 6 Aug 97 7.00

Max	7.2	6.9	4.06	9.9	199.7	3184 5417.3	30.52
Min	0.0	4.7	0.76	6.3	0.0	0 0.0	0.00
Mean	4.9	5.6	2.00	9.0	80.3	1375 2536.5 20.66	13.36
Accm	117.5	134.7	47.94	216.5	1927.9	33004 60864. 5647.	320.82

264.44
 T. of COAL

TIRES
 LBS

AGCS2M000695

ASH GROVE CEMENT - WESTERN REGION SEATTLE PLANT

7/31/97

	RECEIVED / PRODUCED				USED / SHIPPED			INVENTORY
	DAY	MONTH	YEAR		DAY	MONTH	YEAR	
RAW MATERIALS								
LIMESTONE		83,240	496,916			75,677	485,688	34,526
PACIFIC COAST CLAY		4,503	38,190			5,297	37,949	464
CASTLE ROCK CLAY		4,382	26,688			4,029	26,158	751
SUPERIOR SILICA		7,510	42,912			7,505	42,999	319
IRON ORE		1,727	14,734			2,032	14,298	756
SILICA SALES						5,072	9,522	
KILN FEED								
TYPE I		91,231	588,047			90,011	582,627	
TYPE II								9,741
TOTAL								
FUELS (NET)				MTD				YTD
GAS (mmBTU)				3%		3,968	65,592	6%
COAL (mmBTU)				84%		129,835	890,199	82%
TDF (mmBTU)				13%		19,898	130,026	12%
TOTAL (mmBTU)						153,702	1,085,817	
mmBTU/Ton						2.60	2.83	
CLINKER								
PRODUCTION		59,218	384,101			59,453	381,795	27,305
SHIPMENTS							19,067	
ADDITIVES								
GYPSUM		77	18,383			2,488	20,014	3,867
GRINDING AID (Lbs)		43,120	222,920			37,774	216,360	29,700
FLY ASH		216	1,846			203	1767	150
HYDRATED LIME		364	2,080			409	2,102	38
CEMENT								
BULK								
TYPE I-S		59,862	377,008			54,218	304,565	21,712
TYPE II-S		0	0			16,057	85,801	0
TYPE III		2,079	24,801			2,983	25,874	10,692
MASONRY - S								0
OIL WELL-S								0
TYPE III-INK								0
MASONRY-INK								0
OIL WELL-MT								0
TOTAL PRODUCED		61,941	401,809			73,258	416,240	
TOTAL RECEIVED								
GRAND TOTAL		61,941	401,809			73,258	416,240	32,403
SACKS								
TYPE II								
TYPE III								
MASONRY								
TOTAL								
EQUIPMENT DATA								
RAW MILL		486.8	3256.8			187.4	180.6	
KILN		631.7	4060.9			93.7	94.6	
#1 FINISH MILL		503.7	3789.7			50.6	51.2	
#2 FINISH MILL		699.4	4124.5			52.1	50.4	

CHEMICAL ANALYSIS

Raw Mix Clinker

TYPE		
SiO2		
Al2O3		
Fe2O3		
CaO		
MgO		
SO3		
LOI		
Na2O		
K2O		
TOTAL		
FREE CaO		
TOTAL ALK.		
C3S		
C2S		
C3A		
C4AF		

CEMENT	Mill #1	Mill #2
7/31/97		
TYPE:		
SiO2		
Al2O3		
Fe2O3		
CaO		
MgO		
SO3		
LOI		
Na2O		
K2O		
TOTAL		
INSOL		
FREE CaO		
TOTAL ALK.		
C3S		
C2S		
C3A		
C4AF		
NC		
VICAT - I		
VICAT - F		
BLAINE		
45 uM		
30 uM		
FALSE SET		
PACK SET		
REFLECT.		

DAYS SINCE L .L.T. I.

0

Plant Report 16

COAL USAGE

CARMEN

5 Aug 97 - 6 Aug 97

TIRE WEIGH SCALE.....TIRE SCALE PULSE 1 = 10LB
 TIRE WEIGH SCALE LB/HR.....
 NUMBER TIRES BEING BRND.....
 KILN CLINKER BELT SCALE.....
 FLOW RATE KILN PF. FEED.....
 FLOW RATE CALC. PF. FEED.....
 WEIGHFEEDER.....
 WEIGHFEEDER.....

TIRES (LBS/HR)
 ✓

461020.FI1 463210.FI1 471.150.FI1 465075.FI1 TIREBURNPULS
 461120.FI1 463140.FI1 TIRECOUNTER 465.075

H:M	t/h	t/h	t/h	t/h	t/h	Hour
7:00	6.2	6.9	3.43	9.7	87.6	738 0.0 -- 7.34
8:00	6.0	6.5	3.45	9.8	71.7	0 0.0 -- 0.00
9:00	6.0	6.5	3.45	9.4	60.1	0 0.0 -- 0.00
10:00	5.9	6.5	2.04	9.5	55.4	79 2904.7 -- 0.79
11:00	6.0	6.3	3.55	9.4	93.0	202 0.0 -- 1.99
12:00	5.9	6.3	2.07	9.3	28.0	349 2831.7 -- 3.21
13:00	5.9	6.3	1.97	9.2	85.1	490 2889.7 -- 4.71
14:00	5.7	6.1	1.98	9.2	67.9	594 2922.7 -- 6.21
15:00	5.5	5.6	2.02	9.0	53.7	690 2999.7 -- 7.08
16:00	5.5	5.5	2.02	9.1	123.5	842 2988.7 -- 8.37
17:00	5.5	5.5	1.80	9.2	88.2	1003 3276.7 -- 9.87
18:00	5.3	5.3	1.84	9.3	72.4	1161 3230.8 -- 11.37
19:00	5.3	5.3	1.75	9.1	85.0	1305 2721.7 -- 12.87
20:00	4.7	4.8	1.75	9.2	79.0	1453 3276.7 -- 14.32
21:00	4.7	4.8	1.75	9.0	111.4	1593 2476.6 -- 15.85
22:00	4.7	4.8	1.78	8.6	74.9	1749 2227.5 -- 17.32
23:00	4.7	4.8	1.78	8.4	69.4	1918 3270.8 -- 18.81
0:00	4.7	4.8	1.78	8.5	55.5	2083 2831.7 -- 20.31
1:00	4.8	4.8	1.64	8.5	84.5	2250 3276.7 -- 21.81
2:00	4.7	4.8	1.64	8.8	66.7	2406 3131.8 -- 23.31
3:00	4.7	4.8	1.55	8.7	134.3	2569 2032.5 -- 24.80
4:00	0.0	6.2	1.58	8.8	71.3	2703 3276.7 -- 26.09
5:00	0.0	6.3	1.58	8.8	27.1	2864 2966.7 -- 27.59
6:00	5.1	6.1	1.66	8.9	80.9	3032 3157.8 -- 29.09
7:00	6.0	6.1	1.71	9.0	79.5	3184 2659.6 -- 30.53

6 Aug 97 7.00 - 6 Aug 97 7.01

Max	6.0	6.1	1.71	9.0	89.2	3188 3073.8	30.53
Min	6.0	6.1	1.71	9.0	58.3	3185 2373.6	0.01
Mean	6.0	6.1	1.71	9.0	76.2	3186 2805.0 0.02	4.37
Accm	0.1	0.1	0.03	0.2	1.5	62 54.6 5647.	0.09

5 Aug 97 7.00 - 6 Aug 97 7.00

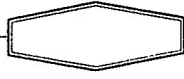
Max	7.2	6.9	4.06	9.9	199.7	3184 5417.3	30.52
Min	0.0	4.7	0.76	6.3	0.0	0 0.0	0.00
Mean	4.9	5.6	2.00	9.0	80.3	1375 2536.5 20.66	13.36
Accm	117.5	134.7	47.94	216.5	1927.9	33004 60864. 5647.	320.82

264.44
 T. of COAL

TIRES
 LBS/HR

AGCS2M000697

ASH GROVE CEMENT COMPANY



"WESTERN REGION"

August 11, 1997

Ms. Melissa McAfee
Puget Sound Air Pollution Control Agency
110 Union Street, Suite 500 Seattle, WA. 98101-2038

Re: Compliance Status Report - July 30, 1997

Dear Ms. McAfee:

Item #1

In regards to N/C 5755 condition 5 and 6, the daily average weight of tire fuel is recorded by the SDR system. Data on gas, coal and tire fuel usage is generated daily. Although this data is available and can be obtained, we are modifying records to reflect this in a simpler format. Attached is an example of the revised format

Item #2 Accumulation of feed material at base of main baghouse has been removed.

Item #3 The written Q/C program is currently being revised. We anticipate this process will require until September 12 to complete.

Item #4 Calibration records for measuring devices for weight determination of kiln fuels.

Coal : On June 10, 1997 Each Pfister feeder was emptied and inspected. A zero curve correction was performed followed by a function test weight in accordance with Pfister technical instructions. Both units were within 1% on the zero. During the function test with the test weight the kiln pfister was approximately 2.5% light and was adjusted. The calciner Pfister was approximately 2% light and was adjusted.

Tires: Weigtech Corp. has been contracted to verify weigh belt calibration. This service is provided approximately every 3 months. Attached are calibration records for April and July .

Natural Gas: Invoice records provided by the gas supplier are used to verify the plant's system for measuring fuel usage.

Sincerely,

Gerald J. Brown
Manager, Safety and Environment
cc: HV

TIRE SCALE.....TIRE SCALE PULSE 1 =10LB
 WEIGH SCALE LB/HR.....NATURAL GAS TON/HR
 NUMBER TIRES BEING BURNED.....TOTAL FUEL IN TPH
 KILN CLINKER BELT SCALE.....PERCENT OF FUEL AS GAS
 FLOW RATE KILN PF. FEED } Coal
 FLOW RATE CALC. PF. FEED } TPH
 WEIGHFEEDER.....
 WEIGHFEEDER..

461010.FIL 463110.FIL 471150.FIL 468075.FIL TIRESCUMPUIS TOTFUEL-TPH
 461110.FIL 463140.FIL TIRESCUMPUIS 4651075 GAS-TPH TIRE-WT90T

H:M	t/h	t/h	t/h	t/h	t/h	Hour	t/h	t/h	%
7:00	4.7	4.5	1.52	7.7	96.7	3084 2904.7	--	34.59	0.1 10.61 12.45
8:00	4.9	4.5	1.52	7.4	89.2	135 3019.7	--	1.49	0.1 10.50 14.18
9:00	5.0	4.5	1.52	7.4	80.5	284 2971.7	--	2.99	0.1 10.57 14.68
10:00	5.5	4.9	3.40	5.9	80.3	422 2986.7	--	4.37	0.1 10.62 11.12
11:00	5.5	4.9	3.39	6.0	90.1	570 3212.8	--	5.78	0.1 10.71 11.67
12:00	5.5	4.9	1.52	7.5	82.1	719 3116.8	--	7.25	0.1 10.55 15.75
13:00	5.5	4.9	1.52	7.4	74.8	852 2911.7	--	8.61	0.1 10.38 12.77
14:00	5.5	4.9	1.55	7.3	103.5	1010 3276.7	--	10.10	0.1 10.55 15.35
15:00	5.5	4.9	1.55	7.1	68.6	1165 2913.7	--	11.60	0.1 10.34 15.67
16:00	5.5	4.9	1.55	7.1	87.1	1315 2769.7	--	13.10	0.1 9.95 12.84
17:00	5.5	4.9	1.53	7.1	76.4	1462 2532.6	--	14.59	0.1 9.95 12.70
18:00	5.5	4.9	1.55	7.1	57.7	1612 0.0	--	15.86	0.1 8.69 0.00
19:00	5.3	4.8	1.61	7.1	95.7	1771 3007.7	--	17.34	0.1 10.26 14.59
20:00	5.0	4.8	1.49	7.1	76.0	1928 3276.7	--	18.84	0.1 10.42 16.66
21:00	5.1	4.7	1.61	7.2	77.6	2077 3267.8	--	20.34	0.1 10.62 16.52
22:00	5.0	4.6	1.61	7.2	151.0	2235 2369.6	--	21.85	0.1 10.29 15.45
23:00	5.0	4.6	1.75	6.5	78.1	2396 2662.7	--	23.32	0.1 9.87 15.57
0:00	5.0	4.5	1.75	7.0	74.2	2549 2976.7	--	24.82	0.1 10.15 12.96
1:00	5.2	4.5	1.75	7.0	96.4	2708 3276.7	--	26.25	0.1 10.58 16.68
2:00	5.2	4.6	1.75	7.1	78.7	2870 3201.8	--	27.71	0.1 10.56 15.92
3:00	6.2	0.0	1.75	7.6	97.6	3008 3276.7	--	29.02	0.1 11.52 18.58
4:00	6.2	0.0	1.75	7.2	82.2	3156 2758.7	--	30.52	0.1 10.46 15.17
5:00	5.5	5.2	1.75	7.4	105.3	3314 3153.8	--	31.99	0.1 10.90 15.58
6:00	5.5	5.2	1.75	7.3	159.6	3468 2728.7	--	33.35	0.1 10.57 15.86
7:00	5.4	5.0	1.73	7.1	66.8	3646 2878.7	--	34.74	0.1 10.12 12.24

11 Aug 97 7.00 - 11 Aug 97 7.01

Max	5.4	5.0	1.73	7.1	70.7	3650 3501.9	34.74	0.1 10.63 16.47
Min	5.4	5.0	1.73	7.1	53.4	3647 2281.6	0.01	0.1 10.02 11.39
Mean	5.4	5.0	1.73	7.1	65.1	3643 2825.4	0.02	4.36 0.1 10.29 15.71
Accm	0.1	0.1	0.04	0.2	1.4	81 65.5 5756.	0.10	0.0 0.23

10 Aug 97 7.00 - 11 Aug 97 7.00

Max	6.3	6.1	3.41	7.7	150.7	3646 7014.7	34.74	0.1 12.56 27.11
Min	4.7	0.0	1.44	5.6	0.6	1 0.0	0.01	0.1 8.20 0.00
Mean	5.3	4.4	1.81	7.1	82.8	1798 2890.3	24.00	17.44 0.1 10.42 13.77 % Tires
Accm	128.2	105.7	434.1	169.7	1987.6	43149 69362. 5756.	418.41	2.3 250.10

213.11
 16/Tires
 Tens Gas

WEIGHTECH CORP.

25837 Dockton Road S.W.
Vashon, WA. 98070
Phone: (206) 463-9535
Fax: (206) 463-5873

GENERAL REPORT

Customer Address: Ashgrove Cement Co.

Seattle, Wa.

Phone # 206 623-5596 X214

Contact: Mr. Bob Minister

Purchase Order 79601457

Plant Site: Same

Date: July 2, 1997

Distribution Same

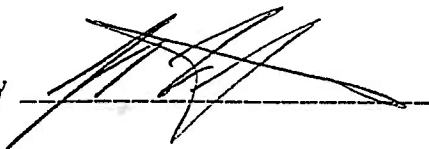
Note condition of conveyor belt, material adhering to belt or pulleys, water or foreign substance any features of conveyor design, drive, take-up, structure, uniformity of weight or general conditions around conveyor, loading, weighing or feed location or others unmentioned that will be detrimental to accurate weighing.

MILLTRONICS MMI-100-COMP III-118HF

The unit was visually inspected. The Compu III integrator, speed sensor, load cells, suspension, idler alignment, and tail pulley assembly appeared to be good order.

The Compu III integrator parameters were verified. The conveyor belt was started and limbered. The actual belt length and speed was determined. The tare test were conducted. The span test were conducted using the test weights. The analog output was not calibrated. The calibration results are attached.

Reported By



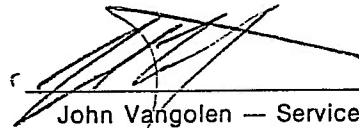
WEIGHTECH

SERVICE CERTIFICATE

This is to certify that on the 2ND day of JULY, 1997,
(day of month) (month of year) (year)

MILLITRONICS machine(s) COMPTON 118H were calibrated using TEST WTS
(equipment manufacturer) (machine serial numbers) (method of calibration)

and did meet and/or exceed the accuracy specification.
Weightech further certifies that the above mentioned units
were found to be in good operating condition
and are being satisfactorily maintained.


John Vangolen — Service Mgr.

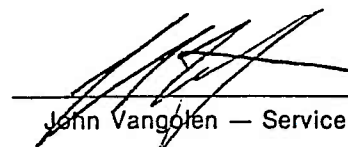
WEIGHTECH

SERVICE CERTIFICATE

This is to certify that on the 18TH day of APRIL, 1997,
(day of month) (month of year) (year)

MILLITRONICS machine(s) 118H were calibrated using TEST WEIGHTS
(equipment manufacturer) (machine serial numbers) (method of calibration)

and did meet and/or exceed the accuracy specification.
Weightech further certifies that the above mentioned units
were found to be in good operating condition
and are being satisfactorily maintained.


John Vangolen — Service Mgr.